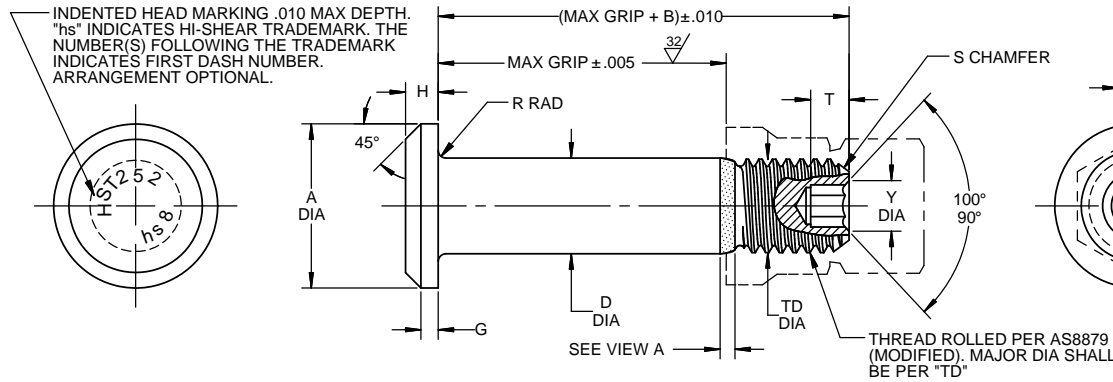
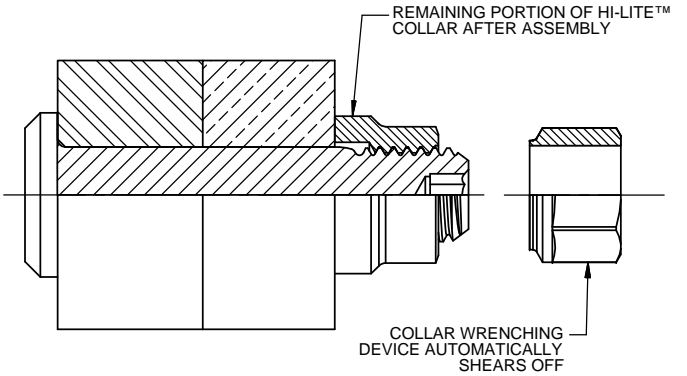


④ For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LITE™ PIN

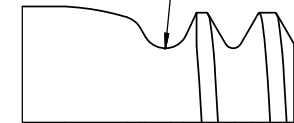


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS
 FOR COLLAR STRENGTHS.
 LOWER STRENGTH (PIN OR
 COLLAR) DETERMINES
 SYSTEM STRENGTH.

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
							NOTE: USE HST152()6-()									
6	7/32	.315	.300	.2182	.2182	.1840	.025	.055	.025	1/32 x 45°	.1900-32	.0806	.100	.119	9,400	3,000
		.295		.2177	.2172	.1810		.045	.015		UNJF-3A	.0791	.080			
8	9/32	.412	.330	.2807	.2807	.2440	.030	.069	.025	1/32 x 45°	.2500-28	.0967	.110	.142	15,500	5,100
		.387		.2802	.2797	.2410		.059	.015		UNJF-3A	.0947	.090			
10	11/32	.505	.390	.3432	.3432	.3060	.035	.078	.030	3/64 x 45°	.3125-24	.1295	.130	.180	23,200	8,000
		.475		.3427	.3422	.3020		.068	.020		UNJF-3A	.1270	.110			
12	13/32	.600	.430	.4057	.4057	.3680	.040	.088	.030	3/64 x 45°	.3750-24	.1617	.160	.217	32,400	11,300
		.565		.4052	.4047	.3640		.078	.020		UNJF-3A	.1582	.140			
14	15/32	.676	.495	.4682	.4682	.4310	.045	.105	.030	3/64 x 45°	.4375-20	.1930	.190	.253	43,100	15,500
		.641		.4677	.4672	.4260		.093	.020		UNJF-3A	.1895	.170			
16	17/32	.770	.535	.5307	.5307	.4930	.050	.116	.030	3/64 x 45°	.5000-20	.2242	.220	.289	55,400	20,000
		.735		.5302	.5297	.4880		.103	.020		UNJF-3A	.2207	.200			

THIS AREA OF SPECIAL CONFIGURATION
 AND COLD WORKING TO MEET PHYSICAL
 REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA
 SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE"
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY J.F.OBISPO	DATE 1996-01-20	TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED MC	DATE 1996-01-21	
REVISION ④	DATE M.BEARD 2017-04-26	DRAWING NUMBER HST252

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
 ④ 2. Dimensions are in inches and to be met after finish.
 ④ 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Oversize replacement for HST52 and HST152.
 ④ ⑥ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HST252-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ ⑥ HST252AC()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ ⑥ HST252AG()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ ⑥ HST252AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ ⑥ HST252GD()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST252TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ HST252HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST252 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

④ **EXAMPLE:**

Pin Part Number
 HST252AP8-8
 └─ 8/16 or 1/2 Maximum Grip Length
 └─ 8/32 or 1/4 Nominal Diameter Pin
 └─ Finish Code
 └─ Pin Basic Part Number

HST252

DRAWING NUMBER

HST252

2 OF 2